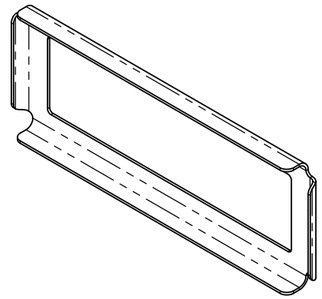

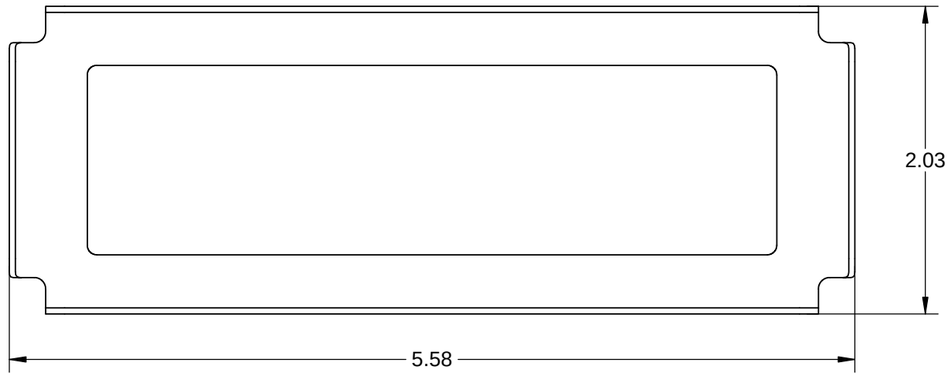


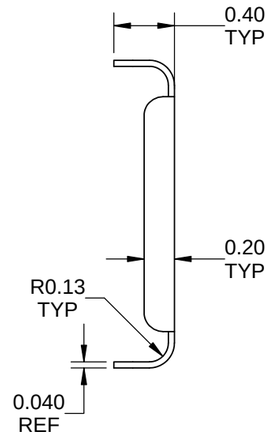


## D4647-1 DOUBLER

**PRELIMINARY ISSUE**

RF 12.04.04

NOTES:
1) MATERIAL: MAKE FROM D4647-1F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.03 lbs

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| PA2 | ADD D4647-3/3F | RF | 12.04.04 |

| | | | |
|---|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | DC | DRAWING NO. D4647 | REV. PA2 |
| MFG. APPR. | | | SHEET 1 OF 4 |
| APPROVED | | TITLE DOUBLER | SCALE NTS |
| DE APPR. | | | |
| DATE | 12.04.04 | | |

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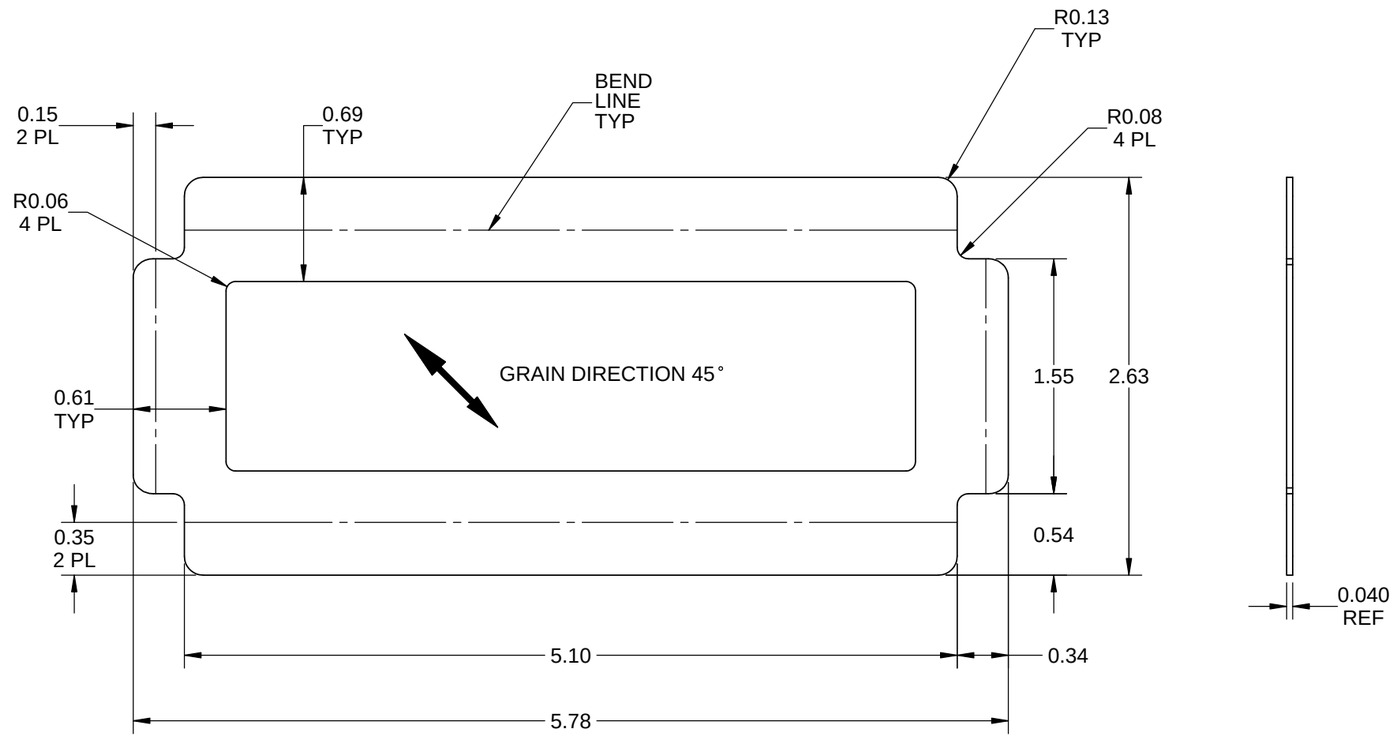


## D4647-1F FLAT PATTERN DOUBLER

**PRELIMINARY ISSUE**

RF 12.04.04

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

| | | | |
|---|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | DC | DRAWING NO. D4647 | REV. PA2 |
| MFG. APPR. | | | SHEET 2 OF 4 |
| APPROVED | | TITLE DOUBLER | SCALE NTS |
| DE APPR. | | | |
| DATE | 12.04.04 | | |

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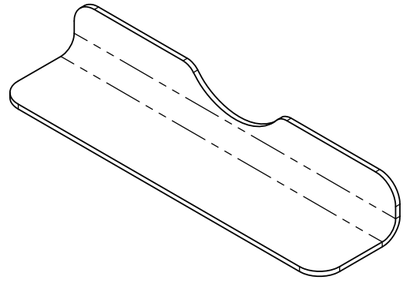

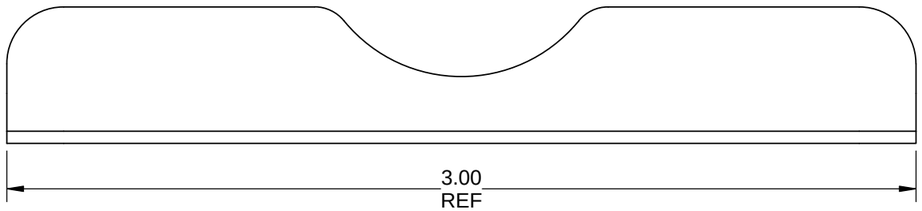


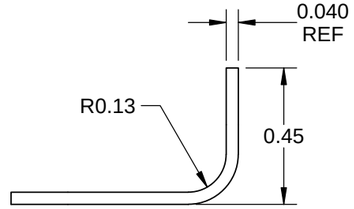


## D4647-3 ANGLE

**PRELIMINARY ISSUE**

12.04.04

NOTES:
1) MATERIAL: MAKE FROM D4647-3F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.01 lbs

| | | | |
|---|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | | DRAWING NO. D4647 | REV. PA2 SHEET 3 OF 4 |
| MFG. APPR. | | | |
| APPROVED | | TITLE DOUBLER | SCALE NTS |
| DE APPR. | | | |
| DATE | 12.04.04 | | |

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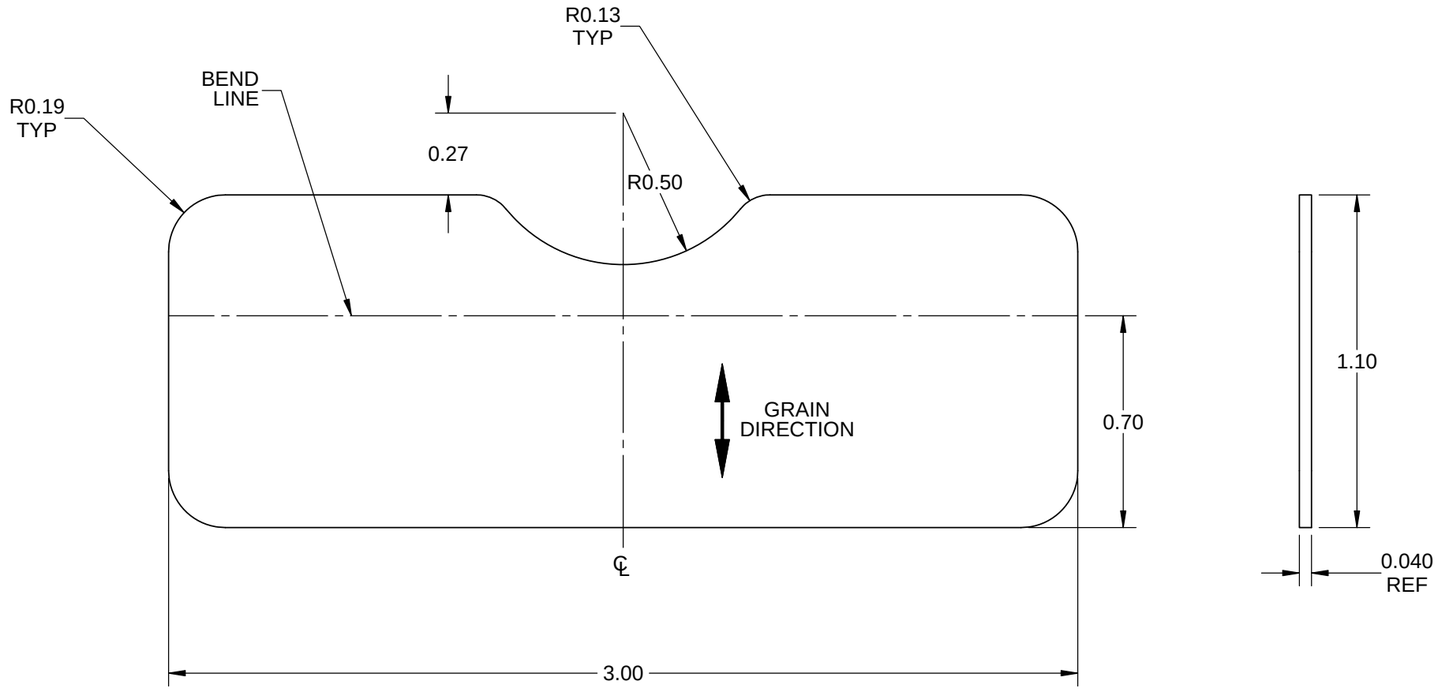


## D4647-3F FLAT PATTERN ANGLE

**PRELIMINARY ISSUE**

RF 12.04.04

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

| | | | |
|---|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | | DRAWING NO. D4647 | REV. PA2 SHEET 4 OF 4 |
| MFG. APPR. | | | |
| APPROVED | | TITLE DOUBLER | SCALE NTS |
| DE APPR. | | | |
| DATE | 12.04.04 | | |

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